SPECIAL SUPPLEMENT

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Winchester Model 70 Take-Down Rifle Supplement

SPECIAL SUPPLEMENT

Winchester Model 70 Classic Custom Take-Down Rifle

U.S. Repeating Arms Company, Inc.
275 Winchester Ave.
New Haven, CT, U. S. A. 06511-1970
Custom Shop Phone: 1-203-789-5503

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Use the space below to record information about your Model 70 rifle.

Model _____ Caliber _____

Serial Number _____

Purchased From_____ Date _____

This precision shooting instrument has been made by the Winchester Custom Shop through a special partnership between U.S. Repeating Arms Company and H-S Precision. H-S Precision is famous for fine tuning and customizing to create rifles with superb accuracy. Your new Model 70 Take-down is no exception. It is one of the most unique, high-performance rifles ever.

SPECIAL WARNINGS FOR THE TAKE-DOWN MODEL 70

IT IS ESSENTIAL THAT THESE OPERATING INSTRUCTIONS AND THE INSTRUCTIONS / WARNINGS PROVIDED IN THE MODEL 70 OWNER'S MANUAL BE THOROUGHLY STUDIED BEFORE USING THIS FIREARM TO ASSURE PROPER AND SAFE GUN HANDLING. FAILURE TO FOLLOW THESE INSTRUCTIONS OR FAILURE TO OBEY ANY SAFETY WARNING MAY RESULT IN INJURY TO YOURSELF OR OTHERS, OR CAUSE DAMAGE TO YOUR GUN.

IF YOUR MODEL 70 OWNER'S MANUAL IS MISSING YOU MUST OBTAIN ONE FROM YOUR DEALER OR US BEFORE USING YOUR NEW RIFLE.

As a gun owner, you accept a set of demanding responsibilities. How seriously you take these responsibilities can be the difference between life and death. There is no excuse for careless or abusive handling of any firearm. At all times handle your rifle and any other firearm with intense respect for its power and potential danger.

PLEASE READ AND UNDERSTAND ALL OF THE CAUTIONS, PROPER HANDLING PROCEDURES AND INSTRUCTIONS OUTLINED IN THIS BOOKLET BEFORE USING YOUR NEW FIREARM.

THE BARREL HALF OF YOUR RIFLE IS DESIGNED AND MADE FOR ONLY THE RECEIVER IT WAS SHIPPED WITH. BARRELS AND RECEIVERS ARE

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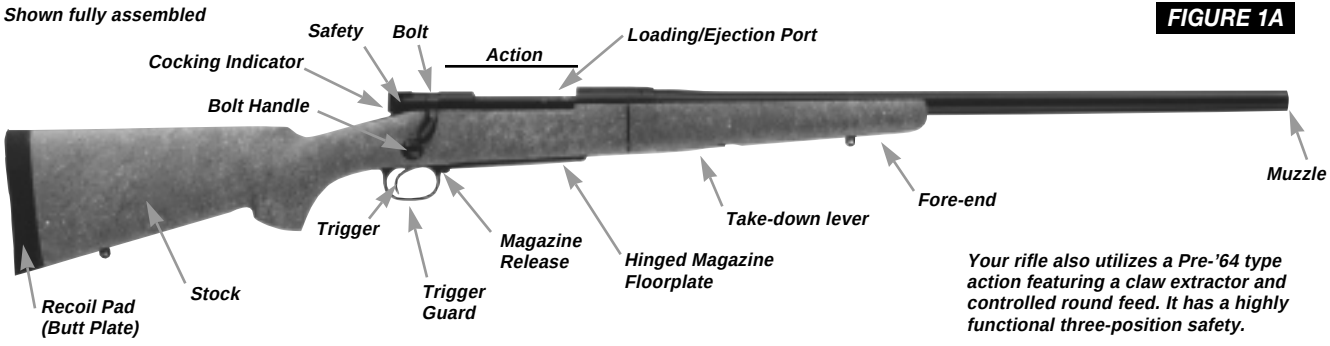


NOT INTERCHANGEABLE. NEVER ATTEMPT TO USE THE BARREL FROM ONE MODEL 70 TAKE-DOWN ON ANOTHER RIFLE.

General Description

Your new Model 70 has unique features found only on the take-down model. ***ALL OTHER GENERAL INSTRUCTIONS AND WARNINGS ARE THE SAME AS FOUND IN THE MODEL 70 OWNER'S MANUAL. IF YOUR MANUAL IS MISSING PLEASE CONTACT US IMMEDIATELY FOR A FREE COPY — BEFORE ATTEMPTING TO USE YOUR NEW RIFLE.***

The Model 70 Take-Down system has the following:

- Accurized Winchester Model 70 long action
- Model 70 trigger assembly
- H-S Precision Pro-Series Match Grade barrel
- H-S Precision Pro-Series kevlar/graphite sporter stock

REFER TO YOUR MODEL 70 OWNER'S MANUAL FOR DETAILS ON THE THREE-POSITION SAFETY AND OTHER FEATURES FOUND ON YOUR NEW MODEL 70.

Terminology and Descriptions

Descriptions in this manual generally refer to the gun in the horizontal position — in the normal firing position. For example, the muzzle is forward or front; the butt stock is rearward or rear; the trigger is downward or underneath; the sight is upward or on top. For general terminology, refer to Figures 1A - C. Throughout this manual the "action" refers to the mechanism of this rifle which loads and secures the cartridge in the chamber. The takedown system utilizes a threaded barrel extension with interrupted threads, which

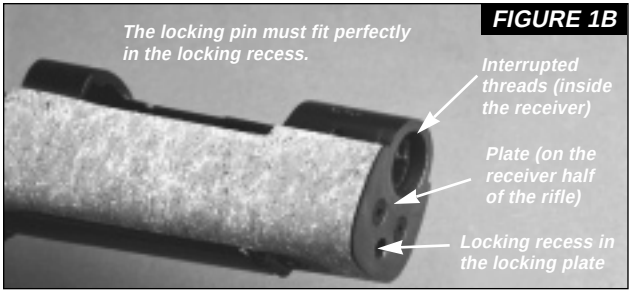


FIGURE 1B
The locking pin must fit perfectly in the locking recess.
Interrupted threads (inside the receiver)
Plate (on the receiver half of the rifle)
Locking recess in the locking plate

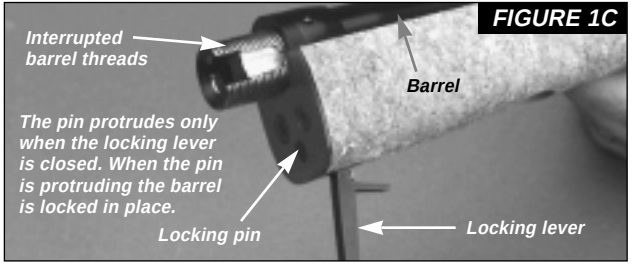
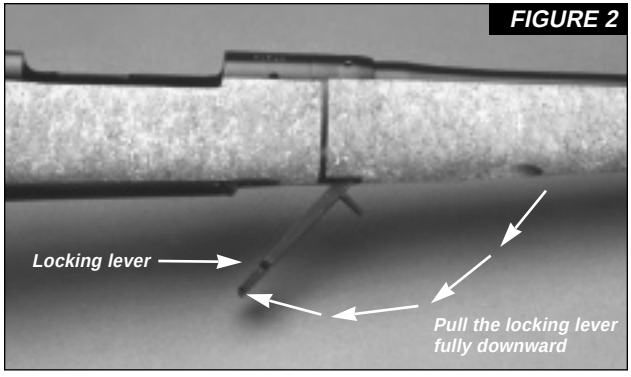


FIGURE 1C
Interrupted barrel threads
Barrel
The pin protrudes only when the locking lever is closed. When the pin is protruding the barrel is locked in place.
Locking pin
Locking lever

allows the barrel to be attached to the receiver with merely a 60° turn. The barrel is locked in place in the receiver with a special, retracting locking pin that is operated using a lever in the forearm.

Serial Number

The serial number is located on both the receiver half of the rifle and the barrel half. The receiver's number located on the right side of the receiver, just forward of the loading/ejection port. The barrel has a serial number (matching the serial number on the receiver) located on the right side of the barrel near the breech. Record the serial number at the front of this book for future reference. The barrel must only be used with the same receiver it was sold with. Barrels are not interchangeable.



Take-down Procedure

When your rifle is fully assembled use this procedure to take it down into its two parts.

COMPLETELY UNLOAD YOUR RIFLE BY REMOVING ALL CARTRIDGES FROM THE MAGAZINE, CHAMBER AND FEED AREAS AS EXPLAINED IN YOUR MODEL 70 MANUAL. MAKE SURE YOUR RIFLE IS POINTED IN A SAFE DIRECTION.

PLACE THE SAFETY IN THE INTERMEDIATE "ON SAFE" POSITION.

1. Remove the bolt assembly completely from your rifle as explained in your Model 70 owner's manual. The barrel will not separate from the receiver unless the bolt is opened/removed.

2. Pull the locking lever downward fully (see Figure 2). This retracts the locking pin from a matching recess in the action.

3. Grasp the barrel half firmly with one hand and the receiver firmly with the other.

4. Turn the barrel assembly counterclockwise 60 degrees. This unlocks the barrel threads from the matching threads in the receiver.

WARNING: IF THE BARREL SECTION WILL NOT TURN WITH RESPECT TO THE RECEIVER DO NOT APPLY EXTRA FORCE UNTIL YOU CHECK AGAIN TO MAKE SURE YOU HAVE FIRST REMOVED THE BOLT FROM THE RECEIVER. APPLYING UNDUE FORCE WITH THE BOLT STILL LOCKED IN THE ACTION COULD DAMAGE THE ACTION.

5. Pull the barrel section forward and out of the action.

6. The barrel is now removed from the receiver and you are holding the two halves of your rifle. Your rifle is now fully taken down (refer to Figure 3).

7. To case or store your rifle in the two halves first return the locking lever to its upward position, flush with the bottom of the forearm. Then reinsert the bolt into the receiver and close it.

NOTE: It is possible to separate the barrel half from the receiver half without removing the bolt completely. However, the bolt must be in the opened position and pulled fully rearward. Taking down your rifle in this way must only be done after you have become completely familiar with your rifle. This is to avoid inadvertently attempting to take down the rifle with the bolt still in place and locked closed and causing damage to the bolt or other components.

FIGURE 3

RE-ASSEMBLY PROCEDURE

If your rifle is taken-down into its two component parts follow these instructions for re-assembly and for preparing your rifle for use.

MAKE SURE YOUR RIFLE IS COMPLETELY UNLOADED. ASSURE THAT ALL CARTRIDGES ARE REMOVED FROM THE MAGAZINE, CHAMBER AND FEED AREAS AS EXPLAINED IN YOUR MODEL 70 MANUAL. MAKE SURE YOUR RIFLE'S MUZZLE IS POINTED IN A SAFE DIRECTION.

PLACE THE SAFETY IN THE INTERMEDIATE "ON SAFE" POSITION.

1. Remove the bolt assembly completely from the receiver as explained in your Model 70 owner's manual.

2. Pull the locking lever on the forearm fully downward (refer back to Figure 2). This retracts the locking pin out of the matching recess on the receiver plate.

3. Hold the receiver half of the rifle in one hand and the barrel half in the other.

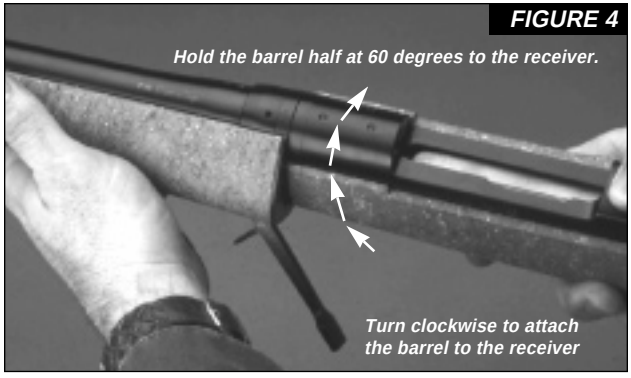
4. Position the receiver half in normal shooting position (top of the receiver upward) and position the barrel half rotated slightly until the bottom of the forearm is on the left side, angled at approximately 60 degrees.

5. Insert the threaded barrel extension fully into the receiver. The interrupted threads on both the barrel extension and in the receiver allow you to insert the barrel into the receiver.

Insert the barrel extension until the plates on the receiver half and the barrel half should are very close together . . . lightly touching, nearly flush. At this point the barrel is fully inserted.

6. With the barrel extension inserted, turn the barrel clockwise 60° to tighten the connection (see Figure 4). A reasonable amount of force should be required to turn the barrel assembly into its proper position.

WARNING: IF THE BARREL SECTION WILL NOT TURN WITH RESPECT TO THE RECEIVER DO NOT APPLY EXTRA FORCE UNTIL YOU CHECK AGAIN TO MAKE SURE YOU HAVE FIRST REMOVED THE BOLT FROM THE RECEIVER. APPLYING UNDUE FORCE WITH THE BOLT STILL LOCKED IN THE ACTION COULD DAMAGE THE ACTION.



If it still will not turn, check to make sure there is no foreign matter (dirt, grit, etc.) between the plates on the receiver and barrel halves. Wipe clean and lightly oil. Try again.

7. With the two halves properly in place, close the locking lever by pushing it fully upward into the recess in the bottom of the forearm. The locking pin should fit into the locking recess in the receiver plate. If it will not, check to make sure there is no foreign matter (dirt, grit, etc.) in the locking recess. Wipe clean and lightly oil. Try again. If the locking pin still will not engage check the alignment of the barrel and receiver. If the barrel section has rotated too far or too little with respect to the receiver, adjustment may be necessary (as explained in the following section).

ADJUSTING THE LOCKING NUT

IMPORTANT: IN THE EVENT THAT THE BARREL ASSEMBLY ROTATES TOO FAR OR NOT FAR ENOUGH USING A REASONABLE AMOUNT OF FORCE, CAUSING THE LOCKING LEVER NOT TO CLOSE, THE LOCKING NUT MAY REQUIRE ADJUSTMENT.

This procedure should only be done if your rifle has gone out of adjustment. A special spanner wrench has been supplied with your rifle. You can determine if your rifle's barrel attachment system is "out of adjustment" by checking for and performing the following:

Barrel assembly rotates too far —

If after inserting the barrel and then turning it to tighten, the barrel goes past the correct position (and the locking pin will not engage the recess on the receiver) then you must tighten the adjusting locking nut. Turn the locking nut counterclockwise (when viewed from the chamber end) using the spanner wrench (refer to Figure 5). This will be an extremely small adjustment which requires trial and error to do correctly. If you inadvertently turn it too far, and the barrel will not rotate enough to close properly, you must loosen the adjusting nut as explained below.

Barrel does not rotate far enough —

If upon rotating the barrel threads into the matching threads in the receiver, the barrel will not rotate far enough for the locking pin to engage you must turn the locking nut clockwise (when viewed from the chamber end) using the spanner wrench (refer to Figure 5).

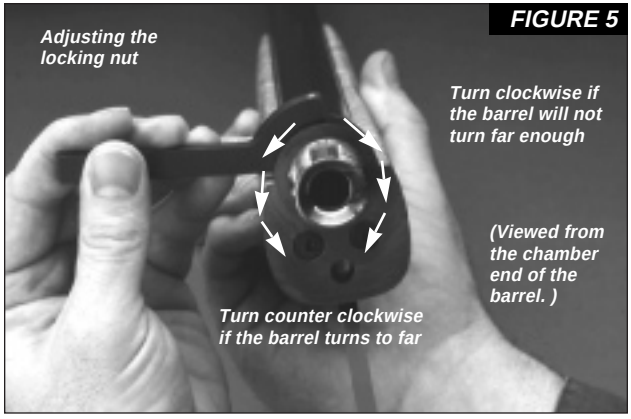


FIGURE 5
Adjusting the locking nut
Turn clockwise if the barrel will not turn far enough
(Viewed from the chamber end of the barrel.)
Turn counter clockwise if the barrel turns to far

Adjust the locking nut until the locking pin lines up perfectly with the matching recess on the receiver plate.

IMPORTANT: THE LOCKING NUT IS NOT TO BE USED FOR SETTING HEADSPACE. YOUR RIFLE HAS CORRECT HEADSPACE SET AT THE FACTORY. THE FUNCTION OF THE LOCKING NUT IS MERELY TO COMPENSATE FOR THREAD WEAR AS THE BARREL ASSEMBLY IS REMOVED AND REINSTALLED INTO THE RECEIVER OVER TIME.

Ordering Parts

To order parts, please write our parts department and furnish: your name, address, telephone number, model name and serial number. We will send an order form and a parts breakdown with prices. Parts Department, U.S. Repeating Arms Company, Inc., 275 Winchester Ave., New Haven, Connecticut 06511-1970.

CAUTION: PARTS ARE MADE FOR WINCHESTER BRAND FIREARMS MANUFACTURED BY OR FOR U.S. REPEATING ARMS COMPANY, INC., AND SHOULD NOT BE USED IN OTHER GUNS EVEN THOUGH MODELS MAY BE SIMILAR. IMPROPERLY FITTED PARTS MAY BE DANGEROUS.

Service / Repair / Questions

For service call or write the Authorized Repair Center (ARC) nearest you or the U.S. Repeating Arms custom shop. For a list of ARCs call: 1-203-789-5000.

You may also utilize the special services of the H-S Precision Company. For information call: 1-605-341-3006.

Custom Shop, U.S. Repeating Arms Company, Inc.,
275 Winchester Ave., New Haven, CT 06511.
Phone: 1-203-789-5503.

On the web: www.winchester-guns.com

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